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D5404-041
Job Sheet 203179



Part No: D5404-041 Job Qty: 4 pcs
Part Name: LH Heavy-Duty Wearplate

Part Weight: 0 lbs Status: New Priority: Medium
Job Created: 11/11/19 Job Tracking No:
Due Date: 12/13/19 Created By: Marie Lajeunesse
Type: SOLD Description:
Note: DWG D5404 REV.PC7 SHEET 1 IPP REV:A 16.03.23 NEW ISSUE DD VERF:JLM IPP REV:B 17.01.05 AS
PER DWG REV.A DD VERF:JLM IPP REV:C 19.05.16 AS PER DWG REV.B DD VERF:JFS
Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Welded Assy-1	4 pcs	12/13/19		0.00	3.20	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
							Large Fab - 12		
110	QC 9	4 pcs	12/13/19		0.00	0.00	QC 9 - 10		
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		
							QC 9 - 50		
							QC 9 - 9		
120	QC 5	4 pcs	12/13/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		



Container No: S239520



Part No: D5404-041

Job No: 203179

Serial No/Batch: S239520

Revision: C
Sector:

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				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	GL
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	DAS
150 Spray Paint - 2 - B4B	4 pcs	12/13/19	0.00 0.67	Spray Paint - 1 - B4B	.47 DEC 14 2019
				Spray Paint - 2 - B4B	9:89
				Spray Paint - 3 - B4B	
				Spray Paint - 4 - B4B	
160 QC 5	4 pcs	12/13/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	DAS
				QC 5 - 30	40
				QC 5 - 40	DEC 16 2019 9:89
				QC 5 - 61	
				QC 5 - 81	
170 Packaging 3-1 - Stock - B4B 4 pcs ✓		12/13/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B ✓	WPOOL
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	

Oscar

DEC 17 2019

					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
180 QC 21 - SA	4 pcs	12/13/19	0.00 0.00	QC 21 - SA - 21 ✓	QC 21 - SA - 70	QC 21 - SA - 53

DEC 17 2019
DEC 17 2019

Part Op 100 - 1- Weld D4155-041 to wearplate as per dwg D5404 304 S.S. Welding Rod BATCH #: MJ38974 2-
Descriptions: Transfer drill holes in bar 3- Use DT9684 to check fit after welding 4- Cut extra material on back end of wearplate if necessary 5- ENSURE WELDED CLAMP FITS AROUND A 3.22" DIAMETER WITH 0.375-0.500 THREAD EXPOSED WHEN SNUG.
110 - QC9- Inspect visual per QSI004- Fusion Welds
120 - QC5- Inspect part completeness to step on W/O
150 - BATCH: MJ39018 COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.020 - 0.040 THICK, PER DART QSI 005 4.9. 5235921
160 - QC5- Inspect part completeness to step on W/O
170 - Identify as per dwg & Stock Location: _____
180 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D4155-041	Wearbar Assembly	4 pcs (1 ea)	100-Large Fab - Welded Assy-1	5197209
D5404-1	Plate	4 pcs (1 ea)	100-Large Fab - Welded Assy-1	5234936
D5617-3	Clamp	12 pcs (3 ea)	100-Large Fab - Welded Assy-1	5235306
D5678-1	Hex Nut	12 pcs (3 ea)	100-Large Fab - Welded Assy-1	5232853

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Welded Assy-1	D4155-041	4	12	0
	D5404-1	4	0	0
	D5617-3	12	0	0
	D5678-1	12	37	0

Part Specifications

Specifications could not be found.

Entered:

Date:

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No.

Route update only



Job: 203179		Part No. DS404-041	
Date: 12-12-16		Sequence #: 100	
DISPOSITION		DEPARTMENT/PROCESS	
Rework Scrap Use-as-is		Skid-tube Machining Large Fab Cross tube Small Fab Finishing Eng. (Non-AW) Prod. Eng. Coord. Rec/Store/Packaging Engineering Water Jet Supplier Quality	
Description Work Order Deviation		QTY Affected: 4034	
Order lap between clamp and wearplate near max allowable, but threads exposed threads at 0.688 when sung. Dwg allowable at 0.35"-0.50".		Disposition	
Remove up to 0.250" of excess thread and ensure exposed thread when sung is within dwg to tolerance		Completed By: EZ 12-12-12	
		Lead hand / Supervisor: EZ 12-12-12	
		QC / QA Coordinator: DB 12-12-16	
Root Cause		FAULT CATEGORY	
Operator Manufacturing Process Equip/Tooling Handling/Preservation Material Product Improvement Process Improvement Human Factors		Contamination Misaligned/off center BOM/Route Broken/Damage/Defect Incomplete/Unclear Instructions Drill Holes Fit/Function Pressure/Forced Bending Crushing Cracks Crimp/Kink/Ripple/Wave/Twist Marks/Chatter Mislabeled Power Loss/Surge Folio/Program Grain Direction Weld Wrong Stock Pulled Out of Sequence Off-set/Set-up Positioned Wrong Outside Tolerance Drawing Finish Part Lost/Missing Misread	
Other/Details:			

H:/FORMS/Quality Assurance/approved QA/NCRWO Rev J